

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000053**Date Inspected:** 18-Jan-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Liu**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** PQR Test plates**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector witnessed welding of a Procedure Qualification (PQR) test plate using gas shielded flux cored arc welding (FCAW-G) using Supercored 71H electrode, in the 2F (horizontal) position. The welding was performed per the AWS D1.5, 2002 Section 5.10 requirements. The welding appeared to comply with the contract documents. The PQR fillet weld test plate weld soundness test was performed in accordance with AWS D1.5-2002 paragraph 5.10.3 and the results were evaluated in accordance with AWS D1.5-2002 paragraph 5.19.3. Caltrans lot number B31-016-07 was assigned for tracking purposes.

On this date the QA representative Joe Lanz arrived at a machine shop operated by Mr. Zhang Sheng Qiang of to witness machining of Procedure Qualification test plates for destructive testing. The test plates appeared to be HP2006129 and HP2006131. The QA inspector observed that machining of samples for reduced section tensile tests, side bends and Charpy V-notch were in progress. The QA inspector observed that all samples were stamp marked prior to machining to maintain traceability. The machining appeared to be in accordance with the requirements of AWS D1.5-2006 section 5. Pictures are on file. The machining was not completed on this date.

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Summary of Conversations:

At the completion of the welding of the test plate the ZPMC QC inspector Mr. Liu Liu reported that the test plate was found to be acceptable in accordance with the contract documents.

At the machine shop the QA inspector met with Mr. Liu Liu of ZPMC and Mr. Zhang Sheng Qiang to discuss the contract requirements for machining.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Lanz,Joe	Quality Assurance Inspector
Reviewed By:	Wright,Mark	QA Reviewer
